

Date: Thursday, 10/25/2007 10:12:29 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : WEARSHOE  
Job Number : 35368  
Estimate Number : 10670  
P.O. Number :  
This Issue : 10/25/2007 S.O. No. :  
Prsht Rev. : NC Part Number : D2924  
First Issue : 1 / 1 Type : SMALL / MED FAB Drawing Number : D2924 REV A  
Previous Run : 27927 Drawing Revision : A  
Material :  
Due Date : 11/10/2007 Qty: 20 Um: Each  
Written By :  
Checked & Approved By :  
Comment : Est: B 02.10.24 Re-format KJ  
Est: C 06.07.17 waterjetEC

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M1010S20GA 1010/1025/A21/6aA SHEET



Comment: Qty.: 0.8222 sf(s)/Unit Total : 16.4430 sf(s)

1010/1025/A21/6aA SHEET

106069 HB 07-10-31

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2924

Dwg Rev: A HB 07-10-31

Prog Rev: A

2-Deburr if necessary HB 07-10-31

(20)

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: DIMENSIONAL CHECK

HB 07-10-31

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

can be 5 7/10/31 (20)

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Deburr and form on brake using DT8326 and DT8261 as per Dwg D2577

HB 07/11/12 (20)

SB

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/25/2007 10:12:29 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 35368

Part Number: D2924

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*07-11-12 (20)*



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



*M105642*



*(20X)*

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*m-1 07/11/13*

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



*(20)*

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*BR 07-11-13*

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

*FR-17*

*BR 07-11-13 (20)*

10.0

QC21

FINAL INSPECTION/W/O RELEASE



*07.11.15*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*U 07.11.14*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	35368
<b>Description:</b> Wearshoe		<b>Part Number:</b>	D2924
<b>Inspection Dwg:</b> D2924 <b>Rev:</b> A		<b>Page 1 of 1</b>	

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.885	+/-0.010	1.886	X			
2.000	+/-0.010	2.000	X			
6.605	+/-0.010	6.605				
11.210	+/-0.010	11.210				
14.710	+/-0.010	14.710				
19.833	+/-0.010	19.833				
24.956	+/-0.010	24.956				
30.079	+/-0.010	30.079				
33.579	+/-0.010	33.579				
0.220	+/-0.010	0.220				
0.300	+/-0.010	0.300				
0.375	+/-0.010	0.375				
R0.375	+/-0.010	0.375				
R0.375	+/-0.010	0.375				
R0.065	+/-0.010	0.065				
R0.13	+/-0.030	0.13				
33.954	+/-0.010	33.954				
0.040	+/-0.010	0.036				

<b>Measured by:</b>	IB	<b>Audited by:</b>	G	<b>Prototype Approval:</b>	N/A
<b>Date:</b>	07-10-31	<b>Date:</b>	21/01/31	<b>Date:</b>	N/A

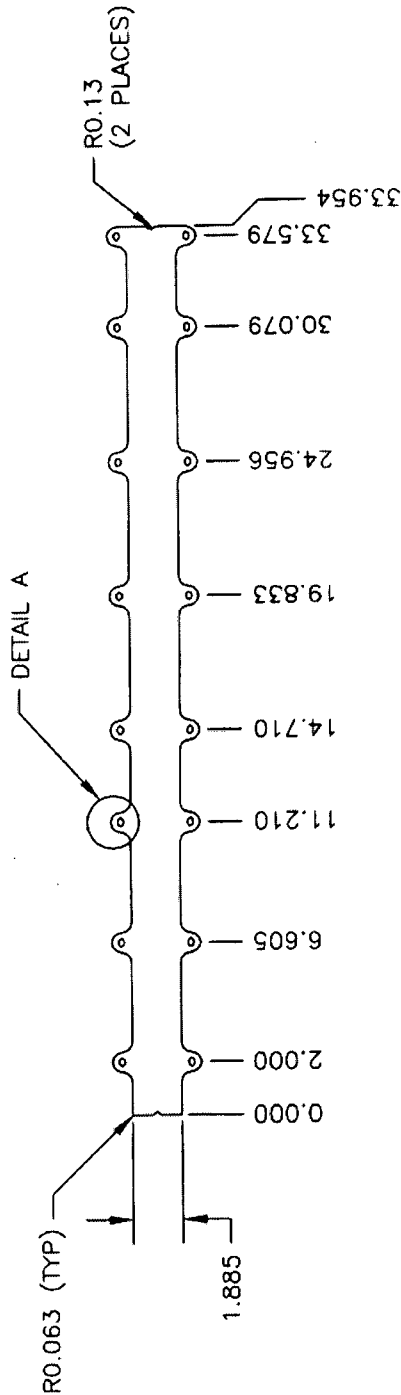
Rev	Date	Change	Revised by	Approved
A	06.09.19	New Issue	KJ/JLM	



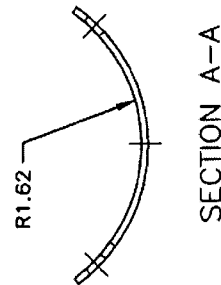
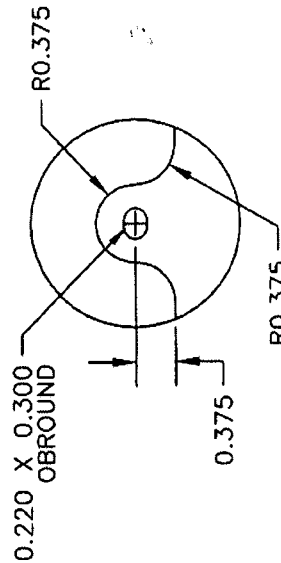
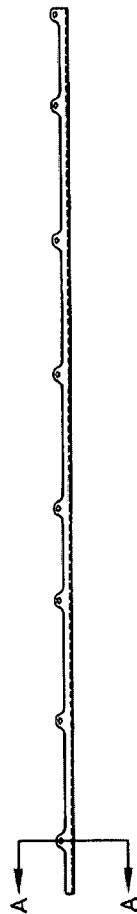
DESIGN RF	DRAWN BY RF	DART AEROSPACE USA, INC. BELLEVUE, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2924	REV. A SHEET 1 OF 1
DATE 99.10.14		TITLE WEARSHOE	SCALE 1:7
A	99.10.14	NEW ISSUE	

RELEASED  
00.05.11

FLAT PATTERN



BENDING DETAIL



DETAIL A

MATERIAL: AISI 1010-1025 OR ASTM A36/A366 SERIES STEEL  
20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 35368